

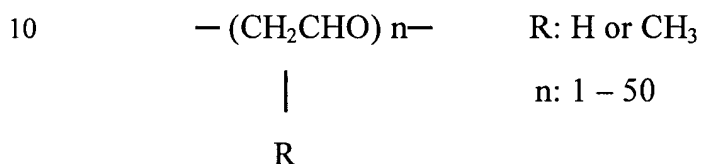
## CLAIMS

1. A process for producing a resin model used in precious casting by a lost wax method comprising at least:
  - 5 a hardened resin layer forming step of injecting two-pack reaction hardening type urethane resin solution (A) with a working life of 1 to 3 minutes through a casting port of a mold for resin model formation defining an internal space whose configuration is identical with that of a product into said internal space in a volume amounting to 5% to 20% of  
10 said volume of said internal space, closing said casting port and rotating said mold for resin model formation, so that a hardened layer of said two-pack reaction hardening type urethane resin solution is formed on an inside wall of said mold for resin model formation;  
a resin model forming step of repeating said hardened resin layer  
15 forming step three to six times at intervals of 3 to 5 minutes so as to effect laminating of hardened resin layers, thereby obtaining a resin model having internal space at a core region thereof; and demolding step of demolding said resin model from said mold for resin model formation.
- 20 2. A process for producing a resin model according to claim 1, wherein:  
said two-pack reaction hardening type urethane resin solution (A) comprises multifunctional polyol component (a), multifunctional polyisocyanate component (b) and a plasticizer component (c), and an  
25 average functional group of said multifunctional polyol component (a) is

2.8 or larger, an average functional group of said multifunctional polyisocyanate component (b) is 2.0 or larger, and a ratio NCO/OH is within 0.7 to 1.0, and further said plasticizer component (c) is preferably micro-dispersed through phase separation at said reaction hardening.

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3. A process for producing a resin model according to claim 1 or 2, wherein said two-pack reaction hardening type urethane resin solution (A) contains polyether chains having a chemical structure indicated in chemical structural formula as follows at 2- 25 wt% thereof.



4. A process for producing a resin model according to any one of  
15 claims 1 to 3, wherein:

a fine wax component (d) is preferably contained within 5 to 40 wt% in said two-pack reaction hardening type urethane resin solution (A).

5. A process for producing a resin model according to any one of  
20 claims 1 to 4, wherein:

said resin model has an internal hollow space whose volume is in a range from 20% to 70% of volume of said resin model.

6. A process for producing a resin model according to claim 5,  
25 wherein said internal hollow space is filled with said wax component (d).

7. A process for producing a resin model according to claim 5, wherein said internal hollow space is filled with foamed urethane.
- 5 8. A process for lost wax precious casting wherein said resin model according to any one of claims 1 to 7 is used.